

Work Order ID 56078

February 9, 2010 3:38:00 PM



Page 1

Item ID:	D3656-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	PANEL					
Start Date:	2/09/10	Start Qty: 2.00		Cust Item ID:		
Required Date:	2/19/10	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-2-09	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3656	Rev B								

100		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks to fit frame size								 10/04/27 XY

110		0.00							
	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987 <input checked="" type="checkbox"/> Dwg. Rev. <u>B</u> <input type="checkbox"/> Folio Rev. <u>C</u>								 10/04/27 XY

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								 10/04/27 XY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3656-3

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 2/09/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/19/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

OK 10/04/28
(x4)

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3656

OK 10/04/28
(x4)

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

OK 10/04/28
(x4)

W/O:		WORK ORDER CHANGES					
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Item ID: D3656-3

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 2/09/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00

5/10/04/27



QC

Memo

0.00



Quality Control

170

Identify as per dwg & Stock Location: 179

0.00



Packaging

Memo

0.00

10-5-35 (4)

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 JF
10-5-04 (4)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 56078

Parent Item: D3656-3

Parent Item Name: PANEL

Comments: IPP Rev. A 07/12/13 New Issue DL verified by:DD
IPP Rev. B 08/09/25 Dwg. Update DL

Start Date: 2/09/10

Required Date: 2/19/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	211.4885	69.3200			
GE PLASTICS LEXAN SHEET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

211.4884526

107574

16.62

111973

180.609853

112176

14.2586

114459

4.

10/04/27
BB

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DART AEROSPACE LTD		Work Order:	56076
Description: Panel		Part Number:	D3656-3
Inspection Dwg: D3656	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: De Date: 10/04/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min	0.045"	✓			
0.045	Min	0.046"	✓			
0.050	Min	0.068"	✓			
60.25	REF	60.25"	✓			
40.75	REF	40.75"	✓			
0.7	REF	0.704"	✓			

Measured by: De Date: 10/04/28
 Audited by: B Date: 10/04/28
 Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	

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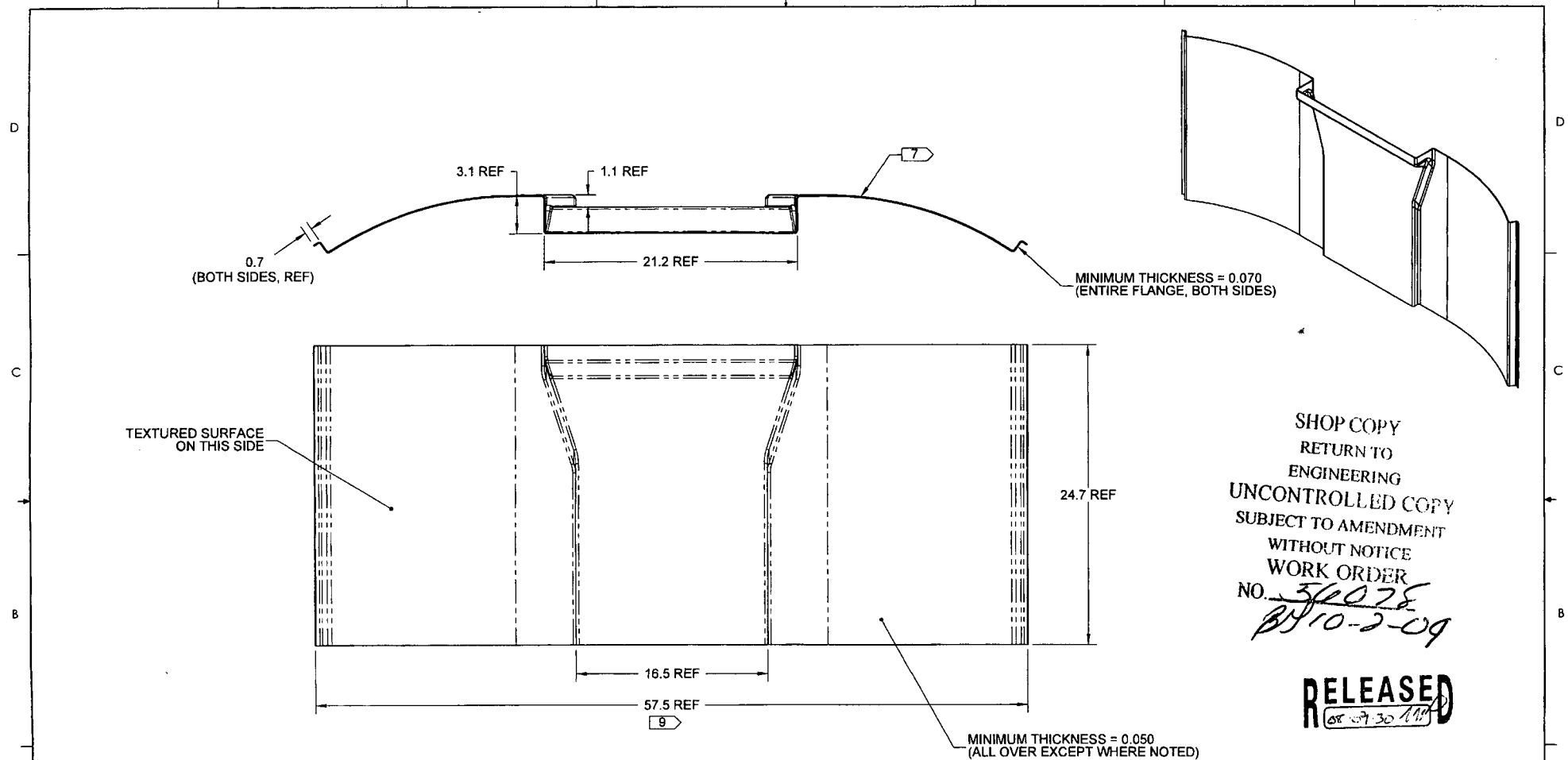
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8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56028
BS10-2-09

RELEASED
08-09-30 1110

D3656-1 PANEL

- NOTES:
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
 - 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER DT8986
 - 3) FINISH: NONE
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
 - 8) WEIGHT: 6.6 lbs
 - 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	h	DRAWING NO.	REV. B
MFG. APPR.	h	D3656	SHEET 1 OF 2
APPROVED	h	TITLE	SCALE
DE APPR.	h	PANEL	NTS
DATE	08.09.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

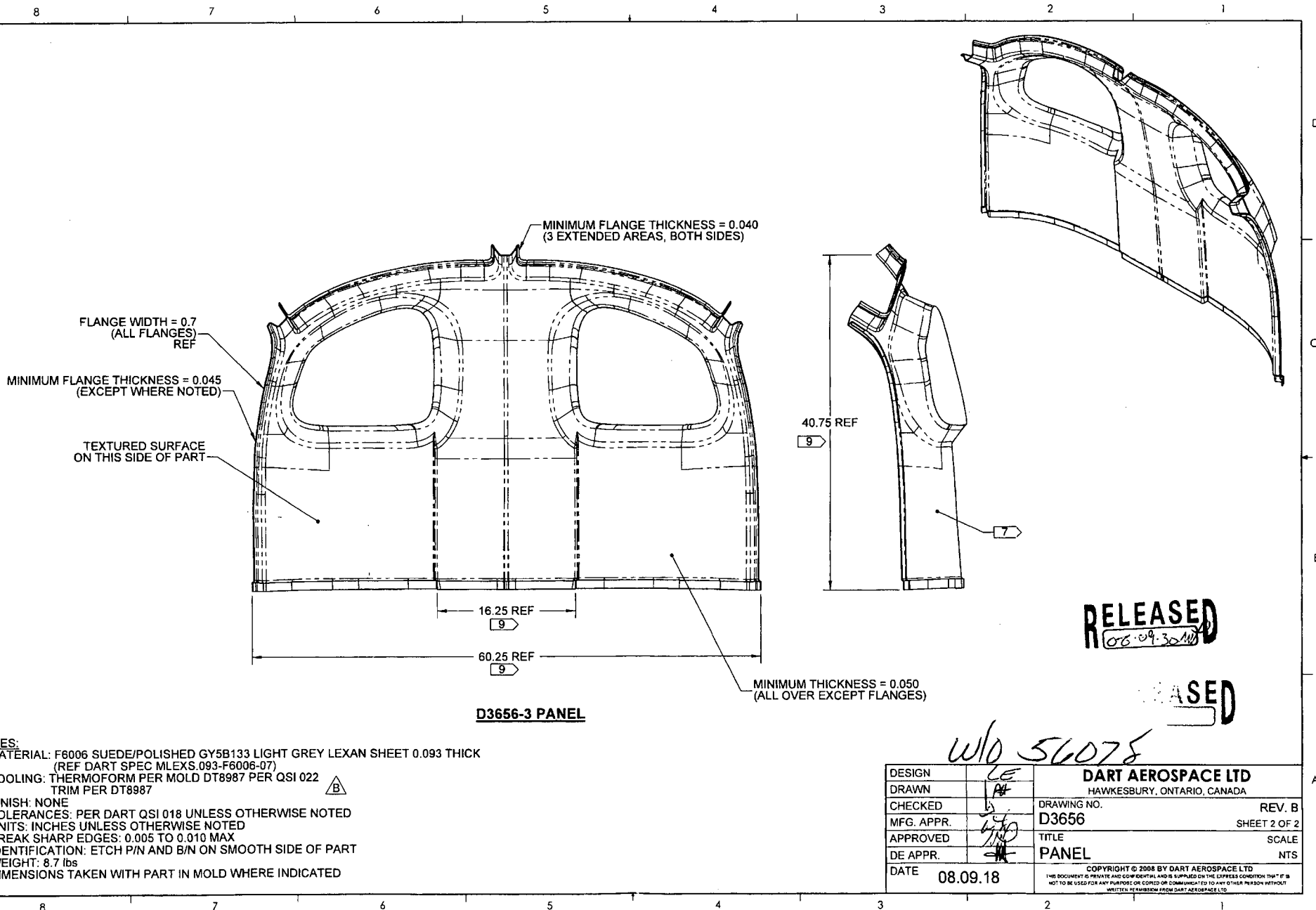
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